Technical Data Sheet

Qr Resin QR-2005IM

Acrylonitrile Butadiene Styrene
LyondellBasell Industries
Engineering Plastics

Product Description	
Available with either high or low gloss.	

General	
Features	• High Impact Resistance
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.04	1.04 g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°c/3.8 Kg)	5.0 g/10 min	5.0 g/10 min	ASTM D1238
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Strength (Yield)	6400 psi	44.1 MPa	ASTM D638
Flexural Modulus	340000 psi	2340 MPa	ASTM D790
Flexural Strength (Yield)	10500 psi	72.4 MPa	ASTM D790
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Notched Izod Impact			ASTM D256
-40°f (-40°c)	1.2 ft·lb/in	64 J/m	
73°f (23°c)	7.0 ft·lb/in	370 J/m	
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Deflection Temperature Under Load			ASTM D648
66 Psi (0.45 Mpa), Unannealed	200 °F	93.3 °C	
264 Psi (1.8 Mpa), Unannealed	185 °F	85.0 °C	

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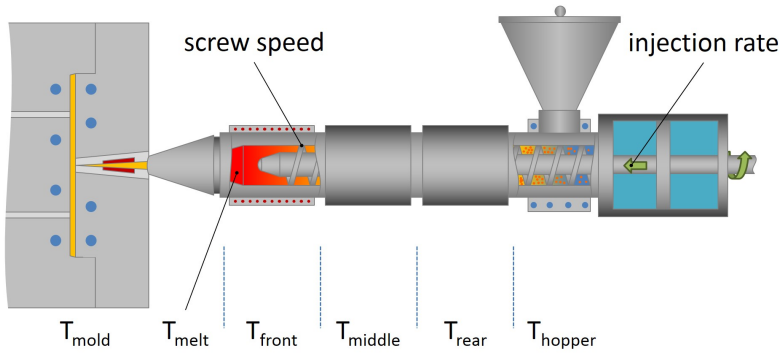

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	200 °F	93 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Drying Time, Maximum	4.0 hr	4.0 hr
Rear Temperature	370 to 410 °F	188 to 210 °C
Middle Temperature	400 to 440 °F	204 to 227 °C
Front Temperature	420 to 460 °F	216 to 238 °C
Nozzle Temperature	420 to 500 °F	216 to 260 °C
Processing (Melt) Temp	420 to 500 °F	216 to 260 °C
Mold Temperature	120 to 160 °F	49 to 71 °C

Notes

These are typical property values not to be construed as specification limits.